

Work Order ID 164286

Monday, July 17, 2017 9:20:26 AM

164286

Page 1

Item ID: D3874-2L02 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector - Pilot Black
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3874	B

110		0.00							DAS 13 9-89
110	THERMOFORMING MACHINE								
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>37108</u>								
	SUPPLIER: PLASTECH								
	MANUFACTURE D3874-2L02 AS PER DWG								
	C OF C IS REQUIRED								

140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140	HAND FINISHING THERMOFORMING								
Packaging	Memo	0.00							
Packaging									

4 JUL 19 2017 **DAS 13 9-89**
4x50 17-8-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
170	Identify as per dwg & Stock Location: <u>St</u>	0.00							
170									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									SEP 06 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							17/9/89
Quality Control									DAS 21 9-89

SEP 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Monday, July 17, 2017 9:20:29 AM

Page 1

Work Order ID: 164286

164286

Parent Item: D3874-2L02

D3874-2I 02

Parent Item Name: Floor Protector - Pilot Black

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev A Added color code to D3874-2 14/07/02 DL
17.06.13 Now outside process DP Verify DD

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3874-2L02P

Purchased

No

110

Each

0.0000

1

4

D3874-2I 02P

**

Floor Protector - Pilot Black

4x17-8-30

M
17.07.17

M LEXS .125 - F6006 - 02
(Black)

Batch: _____ qty per kit 4.40 SF

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

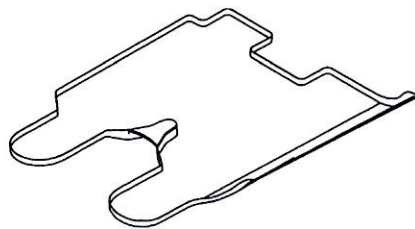
QA Closed: _____ Date: _____

Work Order update only ☐

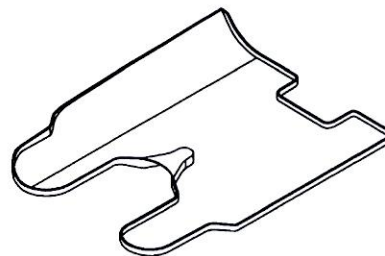
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : ☐									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 164286 MLJ
1707-17



△ D3874-1LXX FLOOR PROTECTOR

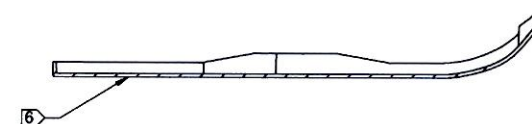
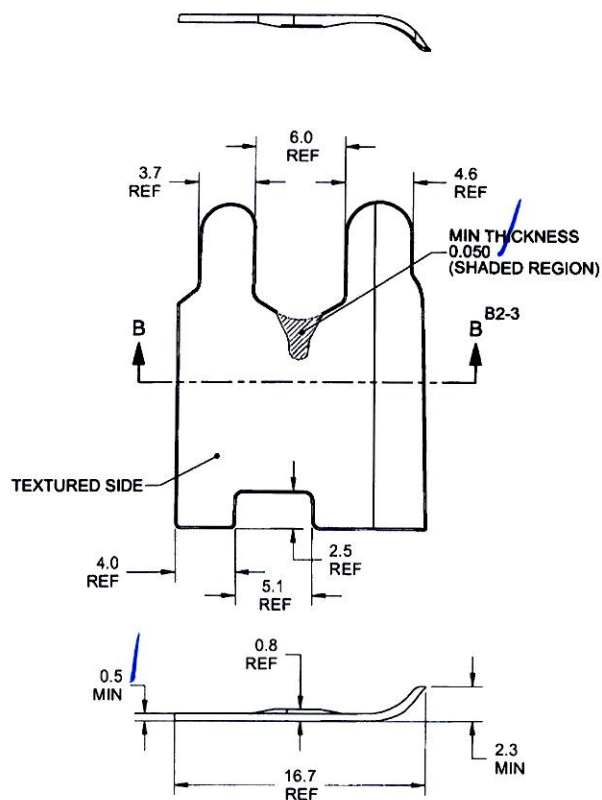


△ D3874-2LXX FLOOR PROTECTOR

RELEASED
2014-06-17

B	ADDED D3874-1L02 AND D3874-2L02 CONFIGURATIONS AND RE-IDENTIFIED D3874-1 AND D3874-2 AS D3874-1L08 AND D3874-2L08. REVISED NOTE 1 AND ADDED MATERIAL TABLE.		AK	14.04.10
A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AK			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.	DL	D3874	SHEET 1 OF 3	
APPROVED	HS	TITLE	SCALE	
DE APPR.	DS	FLOOR PROTECTOR	NTS	
DATE	14.04.10		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



SECTION B-B
SCALE 2X

D3874-2LXX FLOOR PROTECTOR

RELEASED
2014-06-17

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2LXX" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

B

PART NUMBER	DESCRIPTION
D3874-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	D3874	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOOR PROTECTOR	NTS
DATE	14.04.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 4 of 9

Order From :

VC-PLT01

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$400.00

10 D3874-2L02P

Floor Protector - Pilot
Black

7/31/2017 FN

4.00

\$100.00

\$400.00

Yes

Each

7/31/2017

MANUFACTURE AS PER DWG D3874 REV. B
B164286

Line Total: \$400.00

11 D3774-1P

Seat Bottom, LH/RH

7/31/2017 FN

2.00

\$100.00

\$200.00

Yes

Each

7/31/2017

MANUFACTURE AS PER DWG D3774 REV. B
B164283

Line Total: \$200.00

12 D3774-3P

Seat Back, LH/RH

7/31/2017

2.00

\$100.00

\$200.00

Yes

Each

7/31/2017

MANUFACTURE AS PER DWG D3774 REV. B
B164284

Note:

7/19/2017



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37108
Carrier Account #
CU103666

Sales Order
SO-019288

Incoterms
EX WORKS
Ship Via
FREIGHTCOM INC. -

Payment Method
PPD/CHG
Tracking Number

Item Number - Revision	Description	Quantity Shipped	UOM
D3676-1 - Rev.: D	FULL HEIGHT BUBBLE WINDOW (LH) AS PER DWG D3676 REV. D HS Code: 3920.51.1000 - OTHER Country of Origin : CA	2	EA
D4941-1L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-2L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-3L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D4941-4L02 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3874-1L02 - Rev.: B	FLOOR PROTECTOR CO-PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3874-2L02 - Rev.: B	FLOOR PROTECTOR PILOT BLACK AS PER DWG D3874 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D3774-1 - Rev.: B	SEAT BOTTOM AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA
D3774-3 - Rev.: B	SEAT BACK AS PER DWG D3774 REV. B HS Code: 3920.61.1000 - OTHER Country of Origin : CA	2	EA

SP17-8-30

PLAS-TECH
Think Plastics™

SO # SO-019288-010

Part #: D3874-2

Rev: B

Page: 1 of 1

Prototype

✕ First Off

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____ <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratches	✓			

Date: AUG. 24 2017

[illegible]

Date: AUG. 24 2017

Date: _____

Rev.	Date	Change	Revised by	Approved

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3676-1	Qty.	2	Batch #	-001
Description	FULL HEIGHT BUBBLE WINDOW LH 2 SHEETS		Material usage	Lot#	891754
Part #	D4941-1L02	Qty.	2	Batch #	
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	-005
Part #	D4941-2L02	Qty.	2	Batch #	-006
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D4941-3L02	Qty.	2	Batch #	-007
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D4941-4L02	Qty.	2	Batch #	-008
Description	CABIN FLOOR PROTECTORS		Material usage	Lot#	M129722
Part #	D3874-1L02	Qty.	4	Batch #	-009
Description	FLOOR PROTECTOR CO-PILOT BLACK		Material usage	Lot#	M129722
Part #	D3874-2L02	Qty.	4	Batch #	-010
Description	FLOOR PROTECTOR PILOT BLACK		Material usage	Lot#	M129722
Part #	D3774-1	Qty.	2	Batch #	-011
Description	SEAT BOTTOM		Material usage	Lot#	M137737

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: AUG 25, 2017 COFC# 005
(Approved QA Signatory)

Page: 1 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D3774-3	Qty.	2	Batch #	-012
Description	SEAT BACK	Material usage	1 SHEET	Lot#	M137737
Part #	D4634-1P	Qty.	4	Batch #	-013
Description	FWD CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-3P	Qty.	3	Batch #	-014
Description	MIDDLE CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4634-5P	Qty.	4	Batch #	-015
Description	AFT CENTER CEILING PANEL	Material usage	2 SHEETS	Lot#	M135517
Part #	D4635-1	Qty.	3	Batch #	-016
Description	FWD CEILING PANEL, LH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-2	Qty.	3	Batch #	-017
Description	FWD CEILING PANEL, RH	Material usage	3 SHEETS	Lot#	M135517
Part #	D4635-3	Qty.	3	Batch #	-018
Description	AFT CEILING PANEL, LH	Material usage	OFFCUT	Lot#	M135517
Part #	D4635-4	Qty.	3	Batch #	-019
Description	AFT CEILING PANEL, RH	Material usage	OFFCUT	Lot#	M135517

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN
(Approved QA Signatory)

Date: AUG 25, 2017 COFC# 005

Page: 2 of 2

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com